

Work Order ID 61822

Tuesday, September 07, 2010 12:44:18 PM



Page 1

Item ID:	D4104-041	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Doubler Assembly					
Start Date:	9/7/2010	Start Qty:	6.00		Cust Item ID:	
Required Date:	10/13/2010	Req'd Qty:	6.00		Customer:	
Reference:						

Approvals:	Process Plan:		Date:	10-9-07	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4104	A								

100		0.00							
	FLOW WATER JET								
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg								
6061 . 040	Dwg Rev: <u>A</u>								
	Prog Rev: <u>A</u>								
	2-Deburr as required								

110		0.00							
	QC2- Inspect parts off machine FAI/FAIB								
QC	Memo	0.00							
Quality Control									

120		0.00							
	QC8- Inspect parts - second check								
QC	Memo	0.00							
Quality Control									

Diolocho

count
(+20)

10-9-20

10-9-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D4104-041

Accept

Setup Start

Revision ID:

Stop

Item Name: Doubler Assembly

Start Date: 9/7/2010 Start Qty: 6.00

Cust Item ID:

Required Date: 10/13/2010 Req'd Qty: 6.00




Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  Small Fab	Small Fab	0.00							
Small Fab	Memo COUNTER SINK AS PER DWG	0.00							
	Deburr if necessary.								
150  QC	QC5- Inspect part completeness to step on W/O	0.00							
Quality Control	Memo	0.00							
160  HandFinish	Chemical Conversion Coat per QSI005 4.1	0.00							
Hand Finishing	Memo	0.00							

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Accept



Setup Start



Revision ID:

Stop



Item Name: Doubler Assembly

Start Date: 9/7/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 10/13/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

161



QC

Quality Control

QC3- Inspect Part Finish

0.00

M

10/09/22

420

0

Memo

0.00

165



Small Fab

Small Fab

Memo

ASSEMBLE NUT PLATES AS PER DWG

0.00

0.00

EP 10/09/28 (20)

166



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

8/10/21/21

counted
(420)

Memo

0.00

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Cust Item ID:

Required Date: 10/13/2010 Req'd Qty: 6.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

Identify as per dwg & Stock Location: 128

0.00



Packaging

Memo

0.00

Packaging

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/10/29 2010/10/0197

MF 10-9-29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Picklist Print

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Page 1

Work Order ID: 61822

Parent Item: D4104-041

Parent Item Name: Doubler Assembly


Start Date: 9/7/2010

Required Date: 10/13/2010

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP REV:A NEW ISSUE 10-09-06 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.040  6061-T6 .040 Sheet		Purchased	No			100	sf	86.7300	0.03	0.189474			

18 10-9-20

Location

Loc Qty

Loc Code

MAT21

86.73

0.0000

2

12

113004

86.73

Each

11

MS21069-L3

Purchased

No

Nut Plate

MS20426AD3-3

Purchased

No

Rivet

M103447

(Y0X)

4

24

5,021.000

4

24

Location

Loc Qty

Loc Code

ST316

5021

19099

4774

7681

247

111224

9/5/10/09/28

9/5/10/09/28

80

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

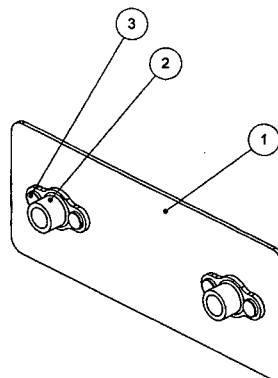
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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ITEM	QTY -041	PART NUMBER	DESCRIPTION
	X	D4104-041	DOUBLER ASSEMBLY
1	1	D4104-1	DOUBLER
2	2	MS21069-L3	NUT PLATE
3	4	MS20426AD3-3	RIVET



SHOP COPY
RETURN TO
ENGINEER
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 61822
BS10 9-07

D4104-041 DOUBLER ASSEMBLY

RELEASED
2010-08-23
MD

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4104-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.02 lbs

A	NEW ISSUE	RF	10.05.06
REV.	DESCRIPTION	BY	DATE
DESIGN	RF		
DRAWN	RF		
CHECKED	<i>[Signature]</i>		
MFG. APPR.	<i>[Signature]</i>		
APPROVED	<i>[Signature]</i>		
DE APPR.	<i>[Signature]</i>		
DATE	10.05.06		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D4104** REV. A
TITLE **DOUBLER ASSEMBLY** SCALE NTS
SHEET 1 OF 2

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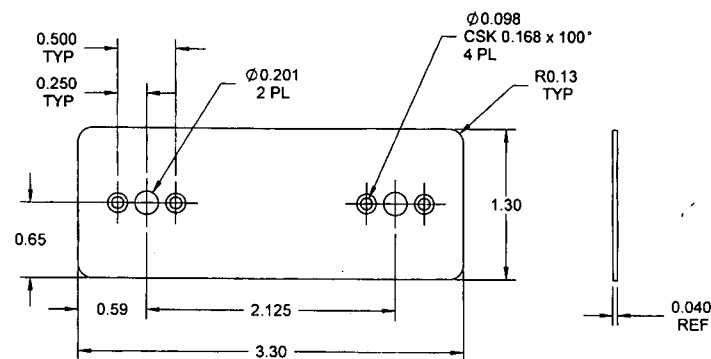
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D4104-1 DOUBLER

w/061822

RELEASED
2010-08-23
ND

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027
OR ASTM B209
REF DART SPEC M6061T6S.040
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.02 lbs

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D4104	SHEET 2 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	DOUBLER ASSEMBLY	NTS
DATE	10.05.06	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. IT IS NOT TO BE USED FOR ANY PURPOSE OR DISCLOSED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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